

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019695**Date Inspected:** 01-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** TOWER & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Weld joint # 01 located on Bike Path BK010A1 – 001. Welder is identified as 053869. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131 – ESAB.

Weld joint # 01 located on Bike Path BK010A1 – 001. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131 – ESAB.

Weld joint # 01 located on Bike Path BK010A1 – 001. Welder is identified as 050295. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2131 – ESAB.

Sub-merged Arc Welding (SAW):

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Weld joint # 007 located on Bike path stringer plate BK009A3 – 001. Welder is identified as 040460. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2. (See attached photo)

Weld joint # 004 located on Bike path stringer plate BK009A3 – 001. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2221 – B – L2c – S – 2.

Heat Straightening:

Heat Straightening being performed on tower head component identified as SSD1-FFSA6-1 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (T) – 11646.

BAY#11

This QA Inspector observed the following work in progress

Flux Cored Arc Welding (FCAW):

Repair welding of weld joint # 44 located on Bike Path BK8A1 – 002 as per the weld repair report # B-WR19147. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – 345 – SMAW – 1G (1F) – Repair. (See attached photo)

Weld joint # 10 located on Bike Path BK4A1 – 061. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 01 located on Bike Path BK4A1 – 061. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Weld joint # 06 located on Bike Path BK4A1 – 061. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Guo Yan Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho- 15002048250, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer